

Work Order ID 161059

Monday, May 08, 2017 9:08:58 AM

161059

Page 1

Item ID: PB67-43001-121

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Square Sleeve

Start Date: 5/10/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/22/2017 Req'd Qty: 5.00

5

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS 21 Date: MAY 08 2017

Tooling: _____ Date: _____

Run Start ***NR1***QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001	D
-----------	---

100

0.00

100

BAND SAW

Bandsaw

Memo

0.01

Jeaspa Bandsaw

Cut blank 4.8" long

5 0 KT-17-05-12
P17-0513

110

2.41

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.84

HAAS CNC vertical machine #1

1- Machine as per Folio FA567 and Dwg PB67-43001
2- deburr

5 KT-17-05-12
P17-0513

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

5 P17-05-13

Work Order ID 161059

Monday, May 08, 2017 9:08:58 AM

161059

Page 2

Item ID: PB67-43001-121**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** Square Sleeve**Start Date:** 5/10/2017 **Start Qty:** 5.00***5*****Cust Item ID:****Required Date:** 5/22/2017 **Req'd Qty:** 5.00***5*****Customer:****Reference:** SCHEDULED/U**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 44 9-09/17-05-15
130									
QC	Memo	0.00				5	0		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.19							201705/16 BER
Hand Finishing									
150	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.48							5 0 17-05-25 334 9-09
Powder Coating	***Mask inside of tube before***								
	START TIME: 9:00								
	OVEN TEMPERATURE: 300°								
	FINISH TIME: 7:20								

Work Order ID 161059

Monday, May 08, 2017 9:08:58 AM

161059

Page 3

Item ID: PB67-43001-121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Square Sleeve

Start Date: 5/10/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/22/2017 Req'd Qty: 5.00

5

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				5			38 9-89
Quality Control									MAY 29 2017
170	Identify as per dwg & Stock Location: WAO03	0.00							
170									
Packaging	Memo	0.00				5x			DAS 26 9-89
Packaging									MAY 29 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							17/5/31 98
Quality Control									

DAS
21
9-89

MAY 30 2017

Picklist Print

Monday, May 08, 2017 9:08:58 AM

Page 1

Work Order ID: 161059

161059

Parent Item: PB67-43001-121

PB67-43001-121

Parent Item Name: Square Sleeve

Start Date: 5/10/2017

Required Date: 5/22/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:EC
REV:B 16.11.22 DWG REV.D DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	11.0000	0.3916	2.061053			

M6061T6B1 250X01 250
6061-T6 Bar 1.25 x 1.25

KA 17-05-12

Location

Loc Qty

Loc Code

MAT003

11

m135377

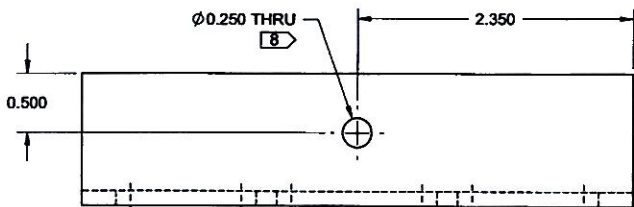
0.667

→ m136327

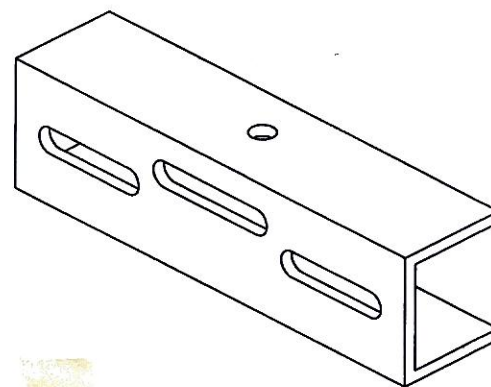
10.333

2.017

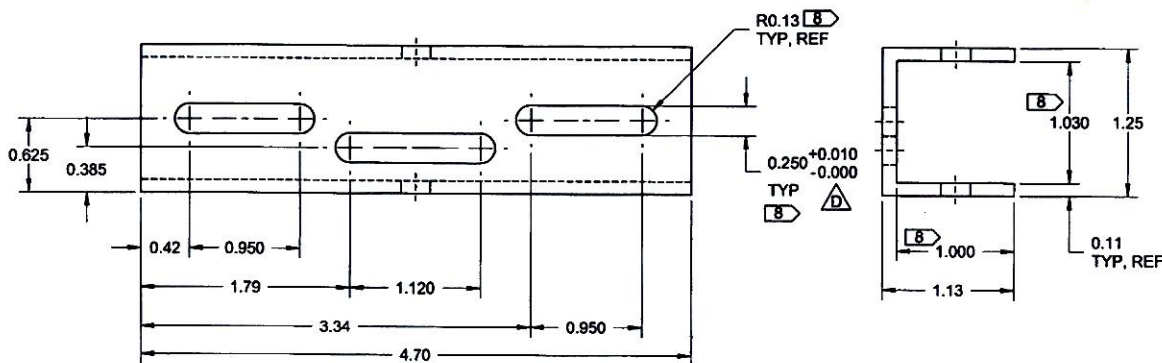
8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 161059 MJS
170508



B67-43001-121 SQUARE SLEEVE



NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6511/T62) BAR
PER AMS-QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs
- 8) MASK ALL OPENINGS AND INSIDE SURFACES PRIOR TO PAINTING.

D	ADDED TOLERANCE ON SLOT WIDTH, UPDATED MATL SPECIFICATION, REASON PARTS-437	SAD	16.10.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 34 OF PREMIER AVIATION DRAWING No. B67-43001; MATERIAL WAS 7075-T6. REASON: SEE PARTS-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO. B67-43001-121	
MFG. APPR.	JLM	TITLE SQUARE SLEEVE	
APPROVED	WM	REV. D	
DE APPR.	N/A	SCALE NTS	
DATE	16.10.14	SHEET 1 OF 1	

RELEASED
2016-11-09
EWS 16-655

APPROVED

COPYRIGHT © 1985 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.